

Date: Monday, 9/11/2006 3:41:09 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 28469		Part Number	: D2803044	
Estimate Number	: 11033		Drawing Number	: D2803 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/11/2006 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/18/2006	
Previous Run	: 28159		Qty:	8	
Written By	:		Um:	Each	
Checked & Approved By	:		S		
Comment	: Est D 05.03.30 MS21043-3 was MS21042L3		KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D28032	STA 84 Bracket		
		5		
		Comment: Qty.: 1.0000 Each(s)/Unit Total: \$0.0000 Each(s)		
		STA 84 BRACKET		B29404 x4
		Pick:		B28180 x1
		Qty Part Number Description Batch		ml07/03/14
		1 D2803-2 Bracket B28184		
2.0	D28054	Stop		
		5		
		Comment: Qty.: 1.0000 Each(s)/Unit Total: \$0.0000 Each(s)		
		STOP		ml07/03/14
		Pick:		
		Qty Part Number Description Batch		
		1 D2805-4 Stop B28183		ml07/03/14
3.0	D2809	Bushing		
		5		
		Comment: Qty.: 1.0000 Each(s)/Unit Total: \$0.0000 Each(s)		
		Bushing		ml07/03/14 (xs)
		Pick:		
		Qty Part Number Description Batch		
		1 D2809 Bushing B30749 x5		ml07/03/14 (xs)
		Press D2805-4 into arm as per Dwg D2803		ml07/03/14 (xs)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:41:10 PM
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Job Number:



Seq. #:	Machine Or Operation:	Description :
4.0	QC3	INSPECT PARTS AS THEY COME OFF MACHINE <i>20703/14 (5)</i>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	POWDER COATING	POWDER COATING <i>M103706</i>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>M10703/14 (5)</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>M10703/14 x5</i>
Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2809 into arm as per Dwg D2803		
8.0	AN3C16A	Bolt <i>M102760 x10</i>
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) 10 Bolt Pick: Qty Part Number Description Batch		
2 AN3C16A Bolt		
9.0	MS210433	Nüt <i>M19099 x10</i>
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) 10 Nut Pick: Qty Part Number Description Batch		
2 MS21043-3 Nut		
10.0	NAS1515H3	Washer <i>M100993</i>
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) 20 Washer Pick: Qty Part Number Description Batch		
4 NAS1515H3 Washer		
A/R LPS-3 Corrosion Spray Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0703-14	4.0	QC 5 required, Remove QC 2. Penn changed				0703-14	0703-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/20

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 28469

Part Number: D2803044

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

ml07/03/19 x5

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml07/03/19 (5)

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

LL

7/03/10 SD (5)

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/10

Job Completion



10/03/20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

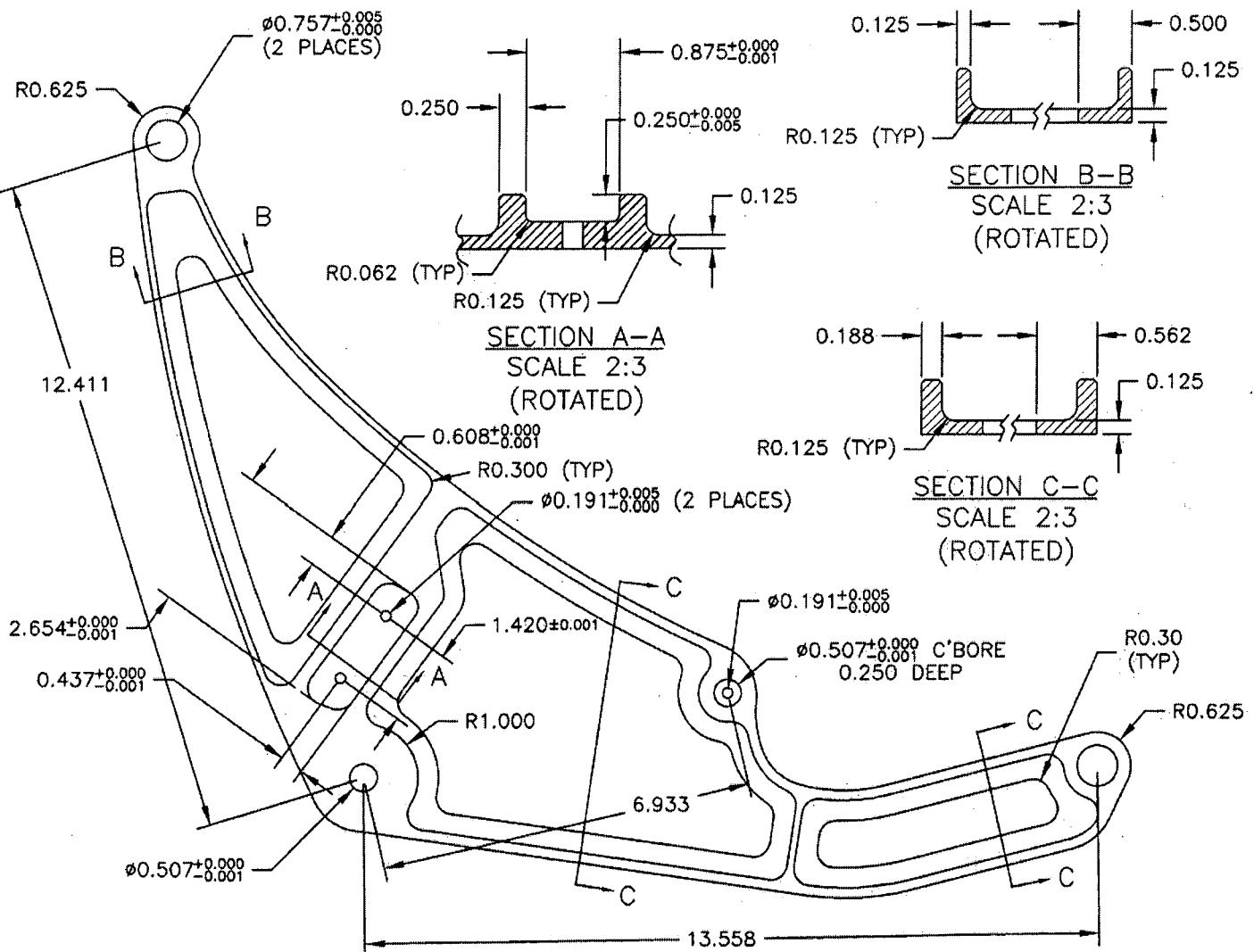
NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
	A 00.11.07	NEW ISSUE	
	B 04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]*



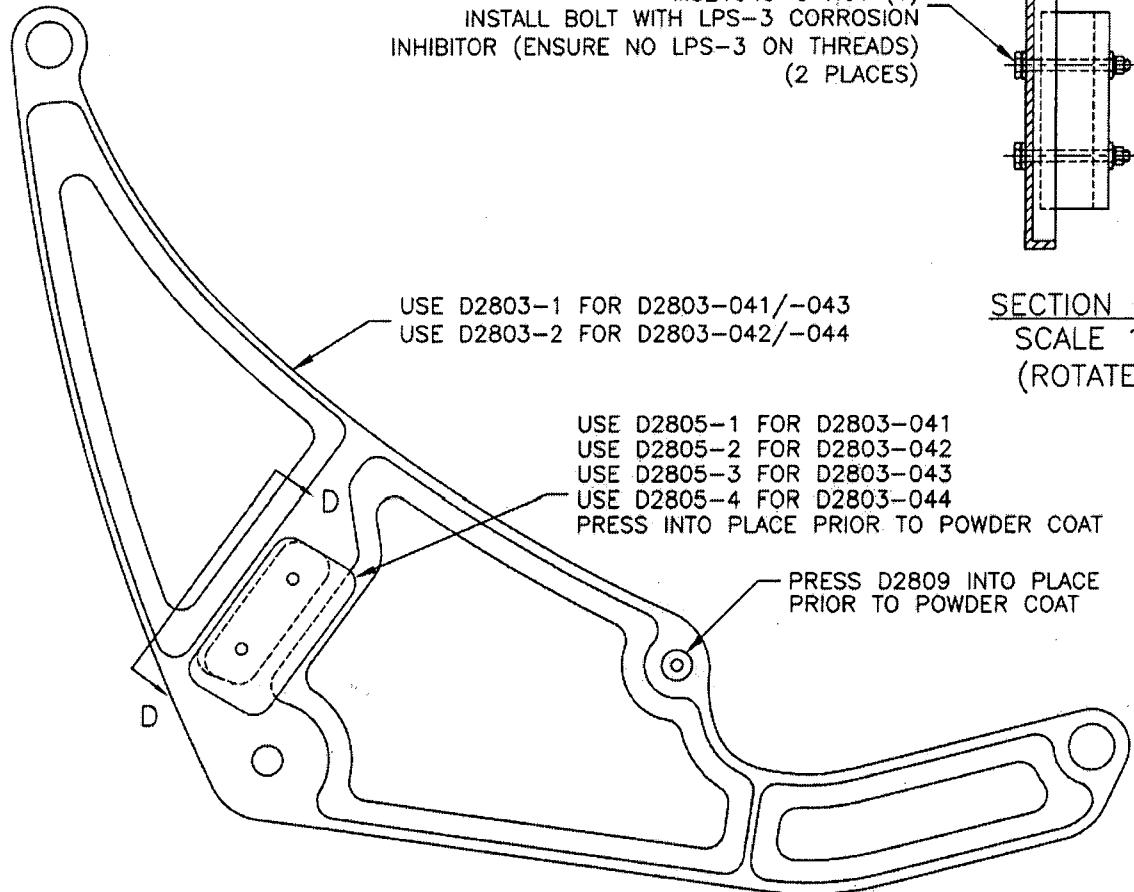
D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28469

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2803
DATE		TITLE STA B4 BRACKET
04.11.22		SCALE 1:3



SECTION D-D
SCALE 1:3
(ROTATED)

D2803-041/-043 BRACKET ASS'Y (SHOWN)
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING
RELEASED
05-03-11
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28461